

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014582**Date Inspected:** 02-Jun-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	Mr.An Qing Xiang/Qiu wen	<b>CWI Present:</b>	Yes	No
<b>Inspected CWI report:</b>	Yes No N/A	<b>Rod Oven in Use:</b>	Yes	No N/A
<b>Electrode to specification:</b>	Yes No N/A	<b>Weld Procedures Followed:</b>	Yes	No N/A
<b>Qualified Welders:</b>	Yes No N/A	<b>Verified Joint Fit-up:</b>	Yes	No N/A
<b>Approved Drawings:</b>	Yes No N/A	<b>Approved WPS:</b>	Yes	No N/A
		<b>Delayed / Cancelled:</b>	Yes	No N/A
<b>Bridge No:</b>	34-0006	<b>Component:</b>	Tower	

**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Nagalingam Pandaram Pillai was present during the times noted above for observations relative to the work being performed.

**IN PROCESS INSPECTION:-****Trail Assembly Area:-**

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: WD1-GUSA3-3-77M-E-4A located on Cross Bracing Gusset Plate. Welder is identified as 040610.ZPMC CWI is identified as Mr.Qiu Wen. The welding variables recorded by QC appeared to comply with the WPS-B-P-2211-TC-U5b-FCM.

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: WD1-GUSA3-3-77M-W-4A located on Cross Bracing Gusset Plate. Welder is identified as 202323.ZPMC CWI is identified as Mr.Qiu Wen. The welding variables recorded by QC appeared to comply with the WPS-B-P-2211-TC-U5b-FCM.

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: WD1-GUSA3-3-77M-N-4A located on Cross Bracing Gusset Plate. Welder is identified as 040582.ZPMC CWI is identified as Mr.Qiu Wen. The welding variables recorded by QC appeared to comply with the WPS-B-P-2211-TC-U5b-FCM.

This QA inspector observed the following work in progress:

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SMAW welding of weld joint no: WD1-GUSA3-3-77M-S-4A located on Cross Bracing Gusset Plate. Welder is identified as 056200.ZPMC CWI is identified as Mr.Qiu Wen. The welding variables recorded by QC appeared to comply with the WPS-B-P-2211-TC-U5b-FCM.

Bay#11:-

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: WSD1-TL5-4B/F-11A located on Lift 5 Grillage Plate. Welder is identified as 040619.ZPMC QC is identified as Mr. Li Bin. The welding variables recorded by QC appeared to comply with the WPS-B-T-3213-B-U3b.

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: ND1-STSA4-10-119M-2-41 located on Strut Plate. Welder is identified as 251194.ZPMC QC is identified as Mr. Liu Dao Feng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2113.

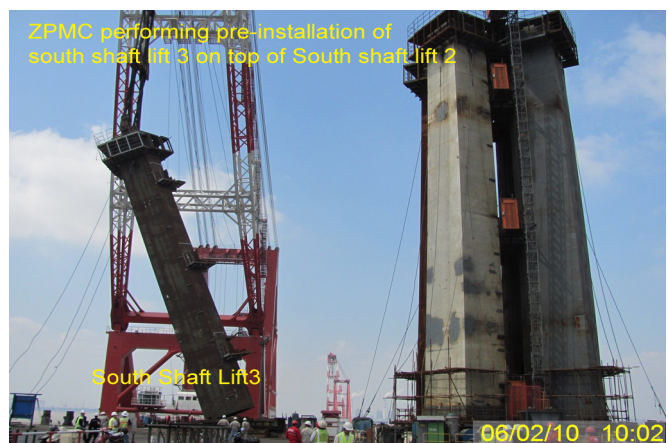
This QA inspector observed the following work in progress:

SMAW welding of weld joint no: ND1-STSA4-10-119M-2-44 located on Strut Plate. Welder is identified as 040614.ZPMC QC is identified as Mr. Liu Dao Feng. The welding variables recorded by QC appeared to comply with the WPS-B-T-4113-1.

This QA inspector observed the following work in progress:

ZPMC performed Buttering on 9M outside Diaphragm plate (SD1-A6).The Buttering area is 5mm thick. The material is A 709M Grade 345 Non-SPCM. Welders are identified as 049220, 053316.ZPMC QC is identified as Mr. Shao Hai Lang. SMAW welding was been performed against Weld repair reportT-WR3329. The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-2G (2F)-Repair.

Unless otherwise noted, all work observed on this date appeared to generally comply with the applicable contract documents.



## Summary of Conversations:

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No Relevant Conversation.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Skyler Guest - 15000422360, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Pillai,Pandaram	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford,William	QA Reviewer

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